

**Work Order ID 78443****\*78443\***

Page 1

January-10-12 7:54:35 AM

Item ID: DSK078

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: D2893-1 TURNING DETAIL

Start Date: 10/01/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 24/01/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan: M.L. 5Date: 12/01/10 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

DSK078

Rev A

100

0.00

**\*100\***

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA081  
(4TH AXIS PLUG DT8492)

110

0.00

**\*110\***

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

120

0.00

**\*120\***

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 78443****\*78443\***

Page 2

January-10-12 7:54:35 AM

Item ID: DSK078 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: D2893-1 TURNING DETAIL  
Start Date: 10/01/2012 Start Qty: 10.00 **\*10\*** Cust Item ID:  
Required Date: 24/01/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	Identify and Stock in Kanban Location: <u>                    </u>								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

SL 12/10/10

12/2/13

11/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January-10-12 7:54:40 AM

Page 1

Work Order ID: 78443

**\*78443\***

Parent Item: DSK078

**\*DSK078\***

Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 10/01/2012

Required Date: 24/01/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-005		Manufactured	No				Each	10.0000		10			
<b>*D6104-005*</b>									<b>**</b>				
Round Billet, 17-4													

Location

MAT043

76834

Loc Qty

10

10

Loc Code

10

*SA 12/2/12*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

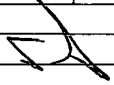
**NOTE:** Date & initial all entries


<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	78443
<b>Description:</b> Turning Detail for D2893-1		<b>Part Number:</b>	DSK078
<b>Inspection Dwg:</b> DSK078 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET



☒ First Article      ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.712	2.712	2.712	2.712	2.712
B	4.946	4.966		4.964	4.959	4.960	4.961	4.961
C	3.064	3.084		3.079	3.072	3.079	3.079	3.079
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.934	2.954		2.944	2.942	2.944	2.945	2.945
G	2.166	2.186		2.174	2.172	2.174	2.174	2.174
H	3.890	3.910		3.901	3.898	3.900	3.900	3.900
I	0.914	0.934		.925	.925	.925	.925	.925
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.109	0.129		.117	.118	.118	.117	.118
L								
M								
N								
O								
P								

**Measured by:**       **Date:** 12/2/17

**Audited by:**       **Date:** 12/02/10

**Prototype Approval:** \_\_\_\_\_      **Date:** \_\_\_\_\_

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





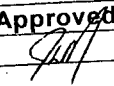
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 78443
<b>Description:</b> Turning Detail for D2893-1		<b>Part Number:</b> DSK078
<b>Inspection Dwg:</b> DSK078 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
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B	4.946	4.966		4.960	4.961	4.960	4.961	4.961
C	3.064	3.084		3.075	3.075	3.075	3.075	3.075
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.934	2.954		2.945	2.945	2.945	2.945	2.945
G	2.166	2.186		2.177	2.177	2.177	2.177	2.177
H	3.890	3.910		3.901	3.900	3.901	3.901	3.901
I	0.914	0.934		.925	.925	.925	.925	.925
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K	0.109	0.129		.117	.117	.117	.118	.117
L								
M								
N								
O								
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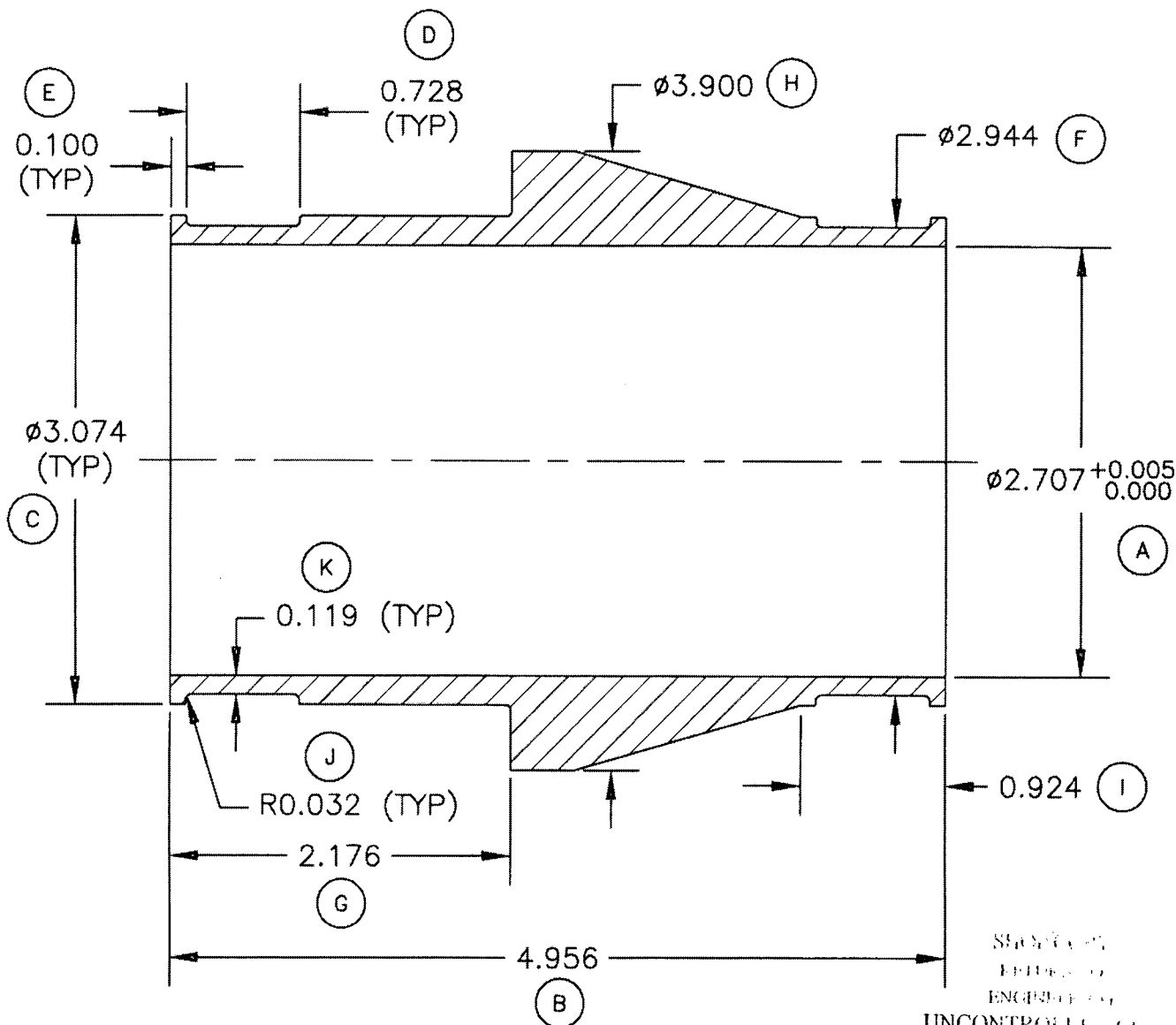
<b>Measured by:</b> 	<b>Date:</b> 12/2/7
<b>Audited by:</b> 	<b>Date:</b> 12/02/10
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED  
# 03.07.01



D2893-1 TURNING DETAIL

STANDARD  
ENTERED  
ENCLOSURE  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO 78443 HLT  
12/01/10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries